

Lincore® 40-S

Key Features

- Designed for rebuilding heavy equipment undercarriages
- Deposit is machinable, hot forgeable, resists rolling and sliding metal-to-metal wear
- Use on carbon and low alloy steels for good puddle control on roundabout welding
- Limited to 4 layers

Typical Applications

- Idlers
- Drive sprockets
- Mine car wheels

Conformances

AS/NZS 2576: 1140 B1*
(nearest equivalent)

Recommended Flux

- Lincolnweld® 802, 880

Diameter / Packaging

| Diameter mm | Part Number | Packaging |
|-------------|-------------|-------------|
| 3.2 | ED015892 | Coil 22.7kg |

Mechanical Properties

| Rockwell – HRC | |
|------------------|---------|
| 3 or more layers | 39 - 42 |

Deposit Composition

| | %C | %Mn | %Si | %Cr | %Mo |
|-------------------------------|------|------|------|-----|------|
| With Recommended Neutral Flux | 0.12 | 2.75 | 0.50 | 3.3 | 0.85 |

Typical Operating Procedures

| Diameter, Polarity, ESO | Wire Feed Speed in/min | Voltage volts | Current amps | Deposition Rate kg/hr |
|-------------------------|------------------------|---------------|--------------|-----------------------|
| 3.2 mm, DC+, 32 mm | 65 | 27 | 330 | 4.4 |
| | 90 | 28 | 425 | 5.9 |
| | 120 | 29 | 525 | 7.8 |
| 3.2 mm, DC+, 65 mm | 80 | 29 | 345 | 5.2 |
| | 110 | 30 | 425 | 7.3 |
| | 145 | 31 | 500 | 9.4 |
| 3.2 mm, DC+, 90 mm | 100 | 31 | 375 | 6.5 |
| | 130 | 32 | 435 | 8.6 |
| | 180 | 33 | 520 | 11.9 |